

Work Order ID 60297

July 1, 2010 12:49:59 PM



Page 1

Item ID: D3417-5

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 02/07/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 40.00

Customer:

Reference:

Ind 10.07.01

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3417

Rev E

100

0.00



Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA761

Rev: &

Dwg D3417 Rev: *D*

2-Deburr

SL 10/07/12

(40)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/07/12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10.7.12

(40)

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Page 2

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Start



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Item Name: Washer

Stop



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Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 053

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/7/13 (40)

10/07/28

MF

10-7-13

Picklist Print

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Page 1

Work Order ID: 60297

Parent Item: D3417-5

Parent Item Name: Washer



Start Date: 02/07/2010

Required Date: 29/07/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A ☐ New issue ☐ 08-07-09 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No			110	f	33.4000	0.0296	1.246316			
DELRIN ROUND BAR 1.25"													

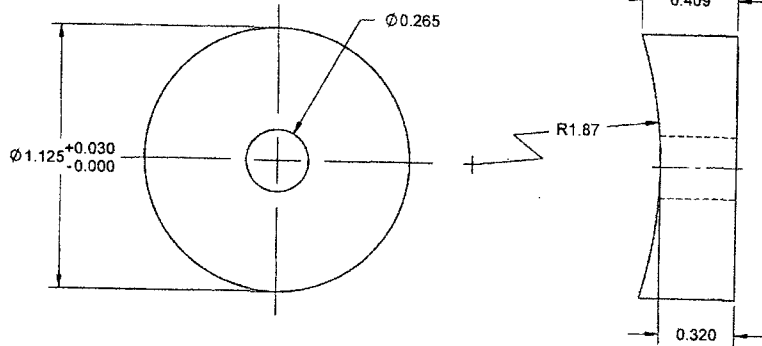
Location

Loc Qty

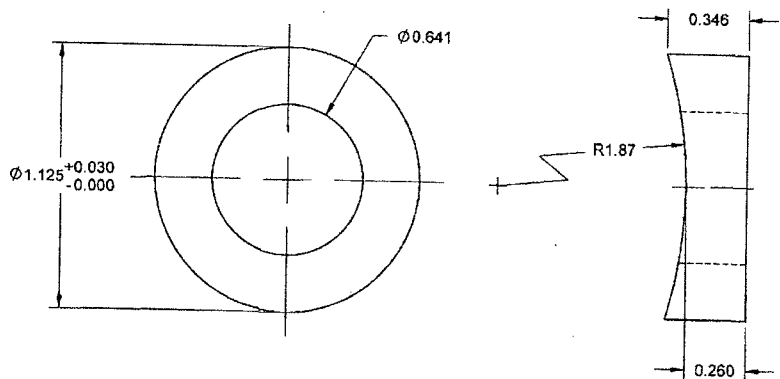
Loc Code

MAT	33.4	
114586	19.3	
114733	14.1	

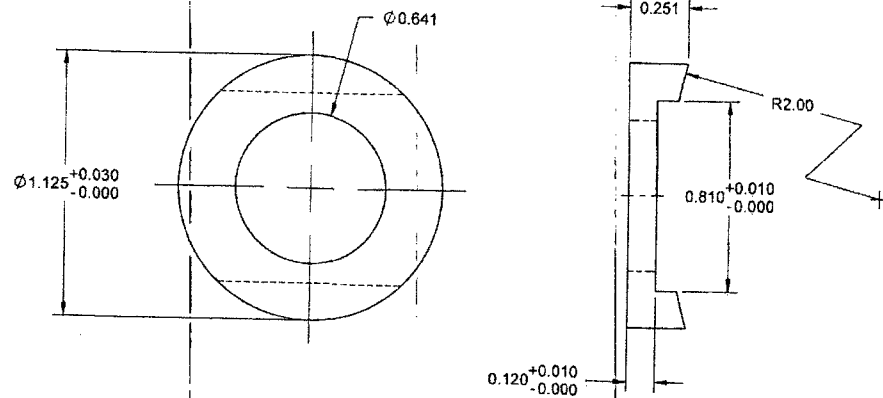
1.25 SL 10/07/12



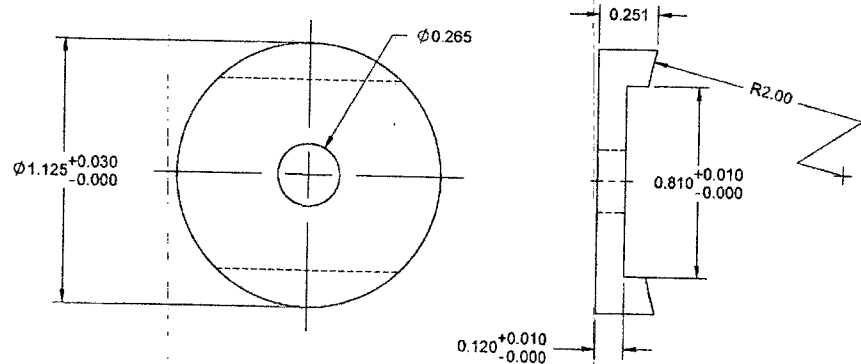
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER

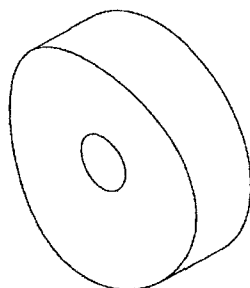


D3417-7 WASHER

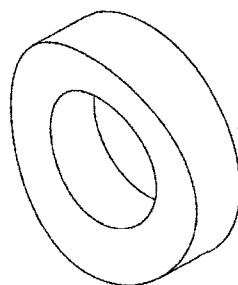
RELEASED
09/15/10

w/p 60297

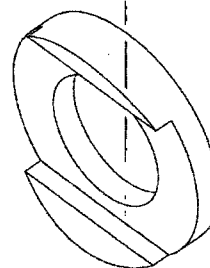
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3417	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	09.06.30	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



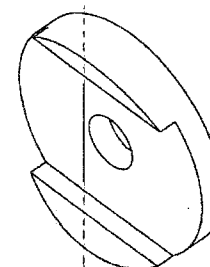
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER \triangle



w/660297
D3417-7 WASHER \triangle

RELEASED
06/15/10

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.02 lbs
D3417-3, 0.01 lbs
D3417-5, 0.01 lbs
D3417-7, 0.01 lbs

E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CSORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3417 TITLE WASHER REV. D SHEET 1 OF 2 SCALE NTS	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DATE 09.06.30 <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	